DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-028851
Date Inspected: 10-Dec-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

CWI Name: Jesse Cayabyab

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
				Approved WPS:	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS Tower

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At Tower Base Electro Slag Weld (ESW) 'V' weld joint #W-043 face B, ABF personnel was observed continuing to perform exploratory excavation on welded ESW at various Y locations; Y=1030mm, Y=1055mm, Y=1090mm, Y=1100mm and Y=1130mm due to UT detected defects. The ABF personnel have resumed the exploratory excavation from 54mm deep where they left off Saturday. The personnel were noted using only the disc grinder in every 1mm increments of excavation. ABF QC Jesse Cayabyab was observed performing Magnetic Particle Testing (MT) on the following various depths with various indications noted mentioned below. This QA also performed the same test and noted same result. During the shift, the ABF personnel continued the excavation in 1mm increments using the same method of test and verification up to 60mm with indications as noted below. The shift was completed up to this depth of excavation.

The starting depth of excavation on this date was a continuation from the previous excavation. The results of the exploratory excavations are as follows;

1. 54mm in depth – no significant indication noted.

2. 55mm in depth –5mm linear indication noted @y=1110mm, X=0.

3. 56mm in depth – 5mm linear indication noted @y=1110mm, X=0; 2mm linear indication at Y=1050mm, X=0

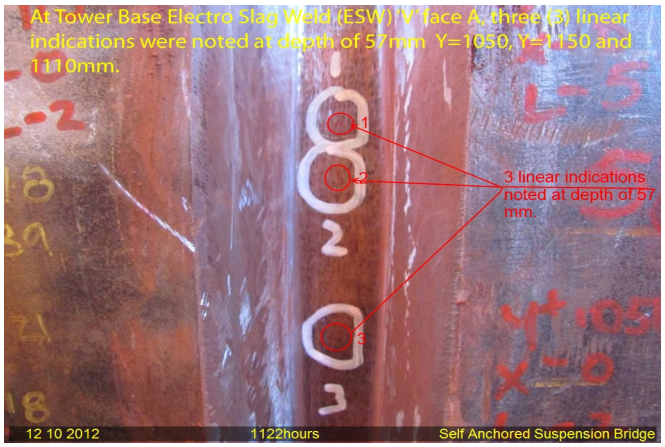
4. 57mm in depth – 5mm linear indication noted @y=1110mm, X=0; 2mm linear indication at Y=1150mm, X=0; 2mm linear indication at Y=1050mm, X=0.

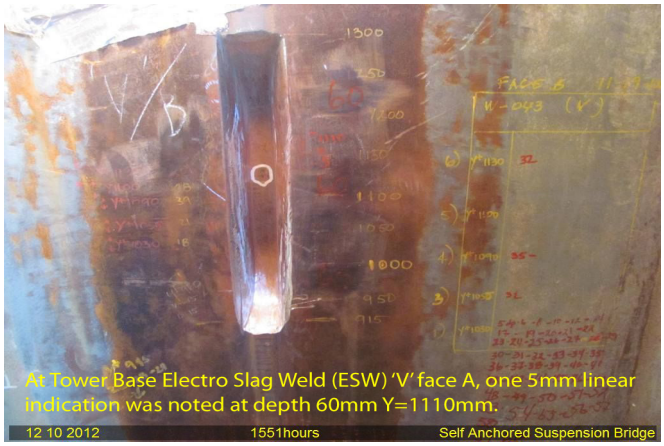
5. 58mm in depth – 5mm linear indication noted @y=1110mm, X=0; 2mm linear indication at Y=1150mm, X=0; 2mm linear indication at Y=1050mm, X=0.

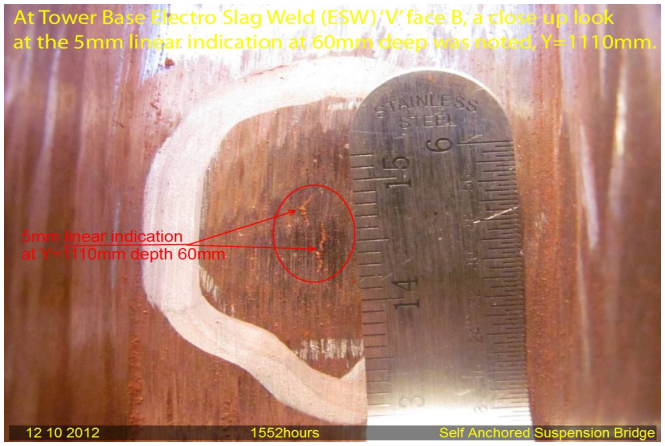
6. 59mm in depth – 5mm linear indication noted @y=1110mm, X=0; the two (2) 2mm linear indications were removed.

7. 60mm in depth – 5mm linear indication noted @y=1110mm, X=0;

The exploratory excavations at this location will be continued on the following shift.







Summary of Conversations:

No significant conversation today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural

Materials for your project.

Inspected By:	Lizardo,Joselito	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer